

Work Order ID 82589

82589

Page 1

April-03-12 10:36:25 AM

Item ID: D412-704-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Assembly (205/212/214/412)

Start Date: 03/04/2012 Start Qty: 4.00

Required Date: 17/04/2012 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-704-041	Rev B								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	Assemble pedal as per Dwg D412-704-041								
	Tighten & Torque Bolts as per Dwg D412-704-041								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Pick Kit	0.00							
120									
Packaging	Memo	0.00							
Packaging									

3x

9/5/12/05/08

8.26.10.02

(x3)

30

12/5/10

W/O:

WORK ORDER CHANGES

DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82589

82589

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April-03-12 10:36:25 AM

Item ID: D412-704-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Assembly (205/212/214/412)
 Start Date: 03/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 17/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		8/16/11		(73)			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>203</u> Memo	0.00 0.00				30	12/5/11		
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/5/11 mf 12-05-11

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82589

82589

Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B05.01.28Removed hardware on Step 2; Added Figures 1-3KJ/RF
IPP Rev:C06.03.08 Re-format EC
IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
IPP Rev:E 07.05.02 Reformat EC
IPP Rev:F 08-10-08 as per revB DD veriified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A *AN3-10A* Bolt		Purchased	No			100	Each	352.0000	1	4		12/05/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				48					
				119084				48					
				ST351				304					
				117795				4					
				120873				300					
AN315-4R *AN315-4R* Nut		Purchased	No			100	Each	31.0000	1	4		12/05/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST344				31					
				17566				31					
AN4-10A *AN4-10A* Bolt		Purchased	No			100	Each	110.0000	1	4		12/05/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				110					
				117619				60					
				121666				50					

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 82589

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-12A

Purchased No

100 Each

655.0000 2 8

AN4-12A

Bolt

**

EP 12/05/08

Location

Loc Qty

Loc Code

ST357

655

115422

4

118628

1

119775

50

120423

600

86

AN4-13A

Purchased No

100 Each

1,371.0000 1 4

AN4-13A

Bolt

**

EP 12/05/08

Location

Loc Qty

Loc Code

ST357

1371

119449

39

120187

92

120422

340

120770

400

121162

500

3

AN960JD10

NAS1149D0363J

Purchased No

100 Each

0.0000 5 20

AN960JD10

Washer

**

EP 12/05/08

AN960JD416

NAS1149D0463J

Purchased No

100 Each

10.0000 11 44

AN960JD416

Washer

**

EP 12/05/08

Location

Loc Qty

Loc Code

ST351

10

116289

10

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Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 82589

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

AN960JD416L

NAS1149D0416J

Purchased

No

100

Each

8.0000

3

12

***AN960.D416I ***

Washer

**

Location

Loc Qty

Loc Code

FP002

8

110153

8

Manufactured

No

100

Each

1.0000

1

4

D3204-041

D3204-041

Release Pedal Assembly

**

Location

Loc Qty

Loc Code

GA

1

79100

1

Manufactured

No

100

Each

4.0000

1

4

D3205-1

D3205-1

Pedal Bracket

**

Location

Loc Qty

Loc Code

GA

4

79350

4

Manufactured

No

100

Each

9.0000

1

4

D3205-3

D3205-3

Back Plate

**

Location

Loc Qty

Loc Code

GA

9

82060

9

Manufactured

No

100

Each

7.0000

1

4

D3206-1

D3206-1

Pedal Arm

**

Location

Loc Qty

Loc Code

GA

7

73469

7

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Page 3

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 82589

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

D3209-041

Manufactured No

100

Each

12.0000

1

4

D3209-041

Bracket Assembly

**

EP 12/05/08

Location

Loc Qty

Loc Code

GA

12

79805

12

MS21042L3

Purchased

No

100

Each

2,461.000

1

4

MS21042L3

Nut

**

EP 12/05/08

Location

Loc Qty

Loc Code

ST300

2461

117441

16

117885

32

118451

5

118927

3

119017

2179

119075

166

121162

60

MS21042L4

Purchased

No

100

Each

4,179.000

5

20

MS21042L4

Nut

**

M12/444 (3x)

Location

Loc Qty

Loc Code

ST300

4179

119017

4

119075

2175

121011

2000

MS24694-S102

Purchased

No

100

Each

27.0000

1

4

MS24694-S102

Screw

**

M12/444 (15x)

Location

Loc Qty

Loc Code

ST289A

27

114382

27

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 82589

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

MS9519-10

Purchased

No

100

Each

14.0000

1

4

MS9519-10

Bolt

**

Location

Loc Qty

Loc Code

ST296

14

100290

14

AN3-6A

Purchased

No

120

Each

362.0000

2

8

AN3-6A

Bolt

**

Location

Loc Qty

Loc Code

ST351

362

117441

36

120498

76

120644

100

121060

50

121166

100

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

0.0000

4

16

*AN960JD10L *

Washer

**

MS21042L3

Purchased

No

120

Each

2,461.000

2

8

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

2461

117441

16

117885

32

118451

5

118927

3

119017

2179

119075

166

121162

60

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Shop Packet Print

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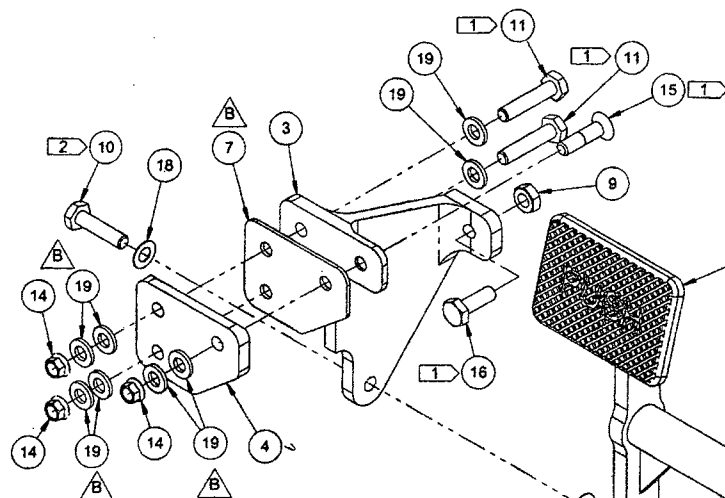
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PARTS LIST:

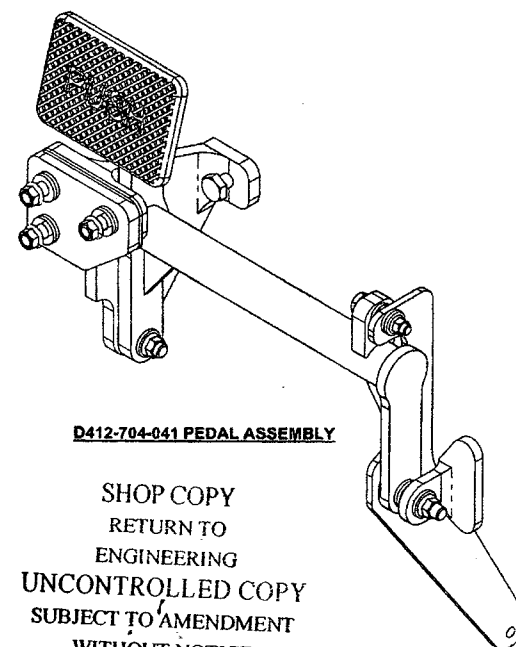
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D412-704-041	PEDAL ASSEMBLY
2	1	D3204-041	PEDAL ASSEMBLY
3	1	D3205-1	PEDAL BRACKET
4	1	D3205-3	BACK PLATE
5	1	D3206-1	PEDAL ARM
6	1	D3209-041	BRACKET ASSEMBLY
7	1	D4610-5	SHIM
8	1	AN3-10A	BOLT
9	1	AN315-4R	NUT
10	1	AN4-10A	BOLT
11	2	AN4-11A	BOLT
12	1	AN4-13A	BOLT
13	1	MS21042L3	NUT (OR MS21042-3)
14	5	MS21042L4	NUT (OR MS21042-4)
15	1	MS24694-S102	SCREW
16	1	MS9519-10	BOLT
17	5	NAS1149D0363J	WASHER (OR AN960JD10)
18	3	NAS1149D0416J	WASHER (OR AN960JD416L)
19	14	NAS1149D0463J	WASHER (OR AN960JD416)
N/A *	2	AN3-6A	BOLT
N/A *	4	NAS1149D0332J	WASHER (OR AN960JD10L)
N/A *	2	MS21042L3	NUT (OR MS21042-3)

EXPLODED ASSEMBLY VIEW

NOTES:

- 1) INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2) TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3) TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)



D412-704-041 PEDAL ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82589 MLJ
12/04/03

RELEASED
2012-03-21
PER ECN 12-545 9P

B	ADD D4610-5 (ZN D8-1); ADD WASHER (ZN A6-1, B6-1, C8-1, D8-1); AN4-11A WAS AN4-12A (ZN B6-1)	RF	12.02.24
A	NEW ISSUE	CB	07.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	RF		
CHECKED	ED		
MFG-APPR	ED		
APPROVED			
DATE	12.02.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D412-704-041**
REV. B
TITLE **PEDAL ASSEMBLY**
SCALE
SHEET 1 OF 1

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